

Work Order ID 138428

Tuesday, October 27, 2015 11:28:17 AM

138428

Page 1

Item ID: D3805-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plate
 Start Date: 10/26/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 10/26/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: OCT 29 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3805	C								

100 0.00
100
 Waterjet
 FLOW CNC Waterjet
 Memo
 1-Cut as per Dwg D3805
 Dwg Rev: C
 Prog Rev: C
 2-Deburr if necessary
 110 0.00
110
 QC
 Quality Control
 Memo
 QC2- Inspect parts off machine FAI/FAIB
 0.00

(5) _____ 02/15/11/05
 (5) _____ 02/15/11/05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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150									
Packaging	Memo	0.00							
Packaging	LOCATION WA001								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.01							
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MCS NOV 06 2015

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OTHER : _____																																																																					

Picklist Print

Tuesday, October 27, 2015 11:28:16 AM

Page 1

Work Order ID: 138428

138428

Parent Item: D3805-5

D3805-5

Parent Item Name: Plate

Start Date: 10/26/2015

Required Date: 10/26/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	295.2000	1.587	6.682105			

M304S18GA

304/316 .050 Sheet

0015/11/05

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	284.7	
M128435	22.9	
M132797	5	
M133328	256.8	
MAT20	10.5	
M131700	10.5	

8.7

DQA: _____ Date: _____



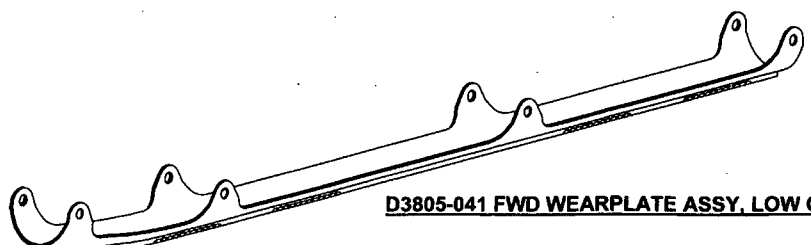
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

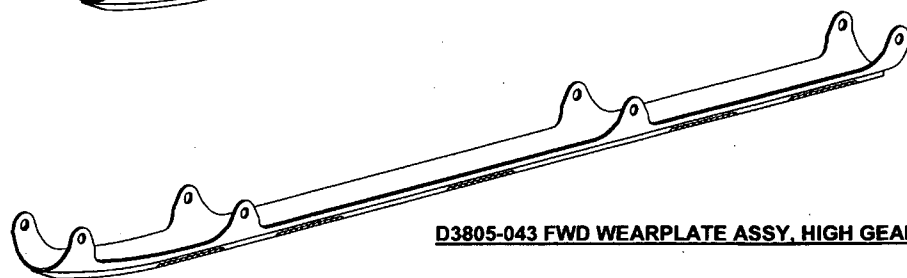
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

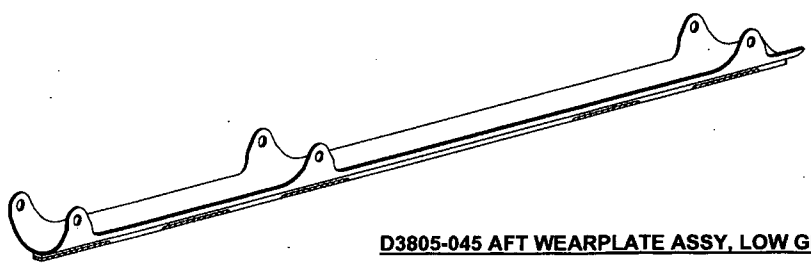
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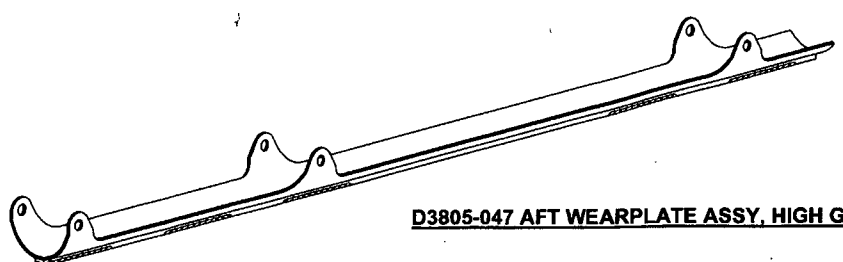
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT

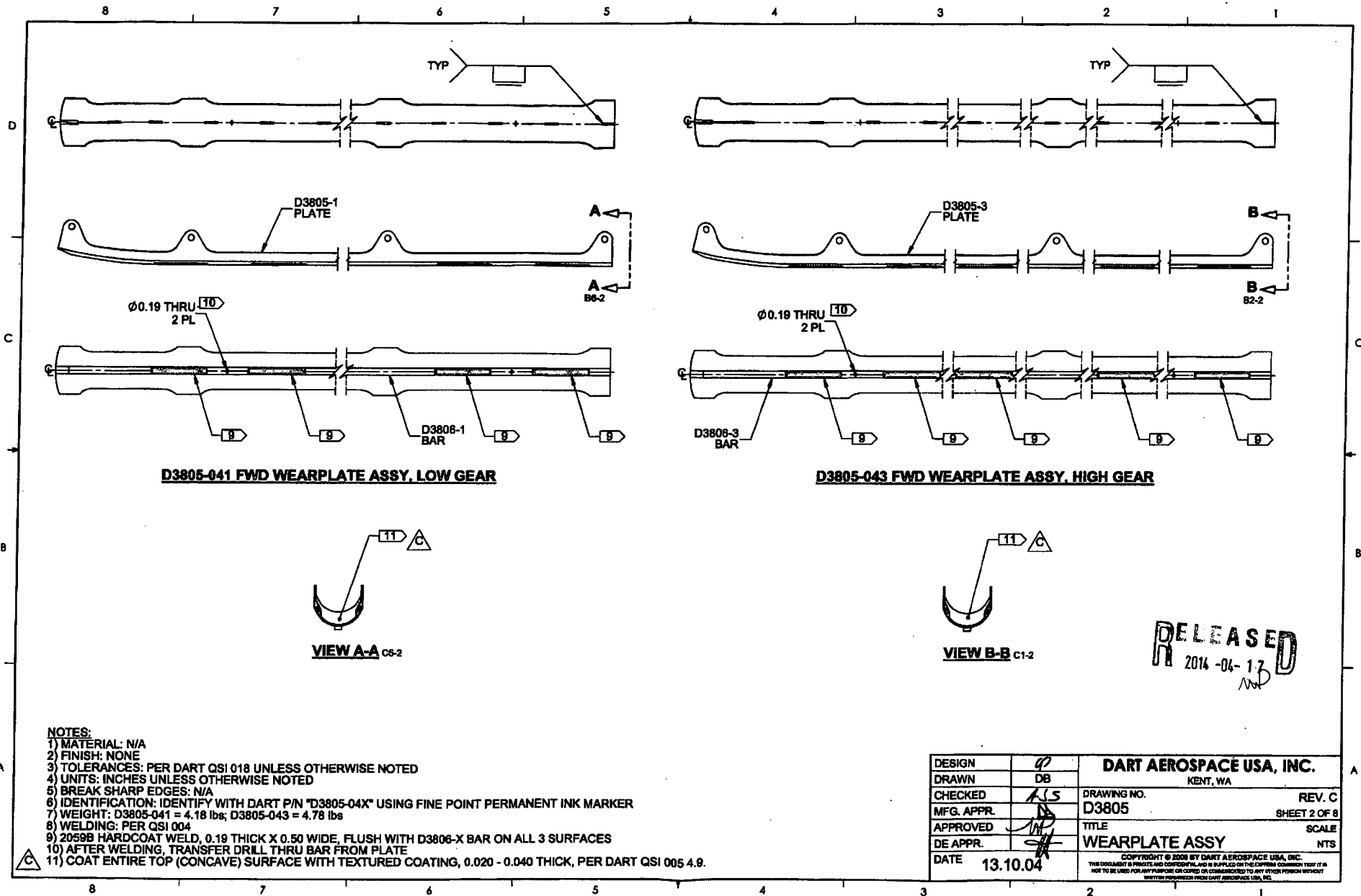
SHOP COPY
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 SUBJECT TO CHANGE
 WITHOUT NOTICE
 WORK CENTER

NO. 138428 HLT
 15-10-29

RELEASED
 2014-04-17

C	REMOVE ITEMS 19, 20, 21, 22 AND 32 FROM BOM (ZN C4-1); REVISE NOTE 11; SHEETS 2&3 (ZN A8-2, B2-2, B6-2, A8-3, B2-3, B6-3)	DB	13.10.04
B	REVISED D3805-1F/3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PAR11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.10.04	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

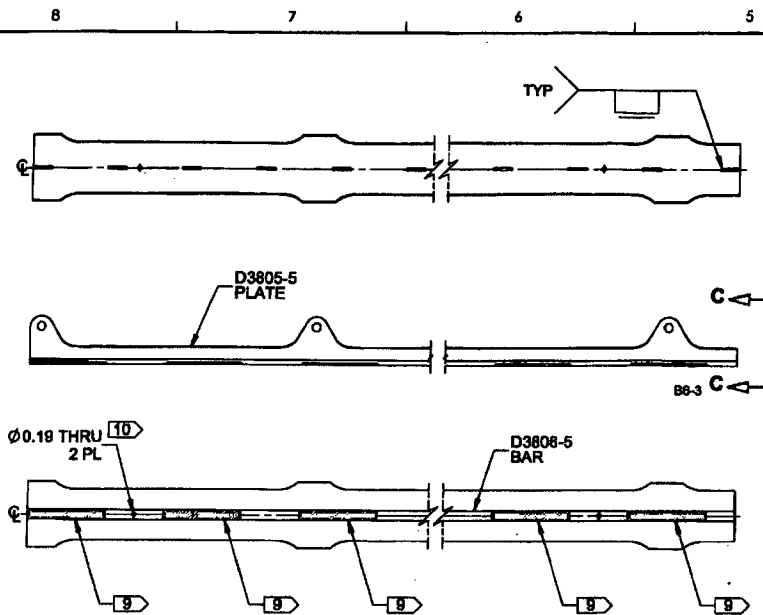
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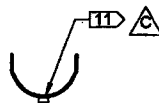
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

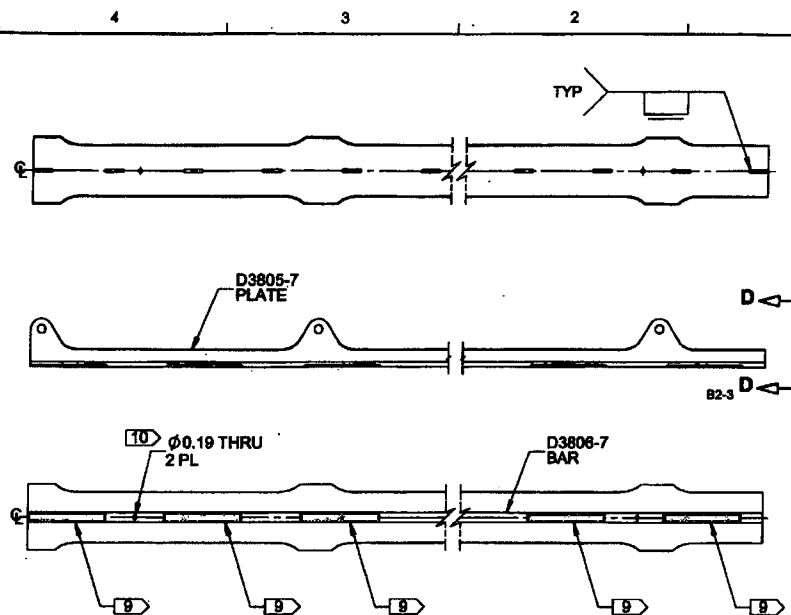
DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	DB	D3805	SHEET 2 OF 8
APPROVED	DB	TITLE	SCALE
DE APPR.	DB	WEARPLATE ASSY	NTS
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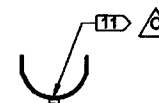
D3805-045 AFT WEARPLATE ASSY.



VIEW C-C C5-3



D3805-047 AFT WEARPLATE ASSY.



VIEW D-D C1-3

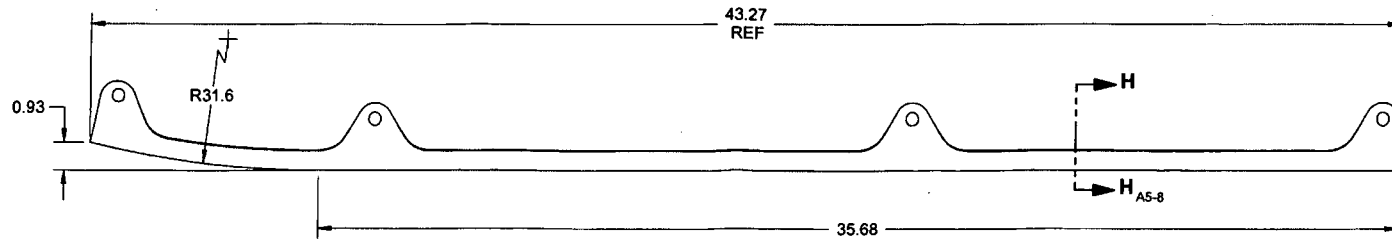
RELEASED
2014-04-17

NOTES:

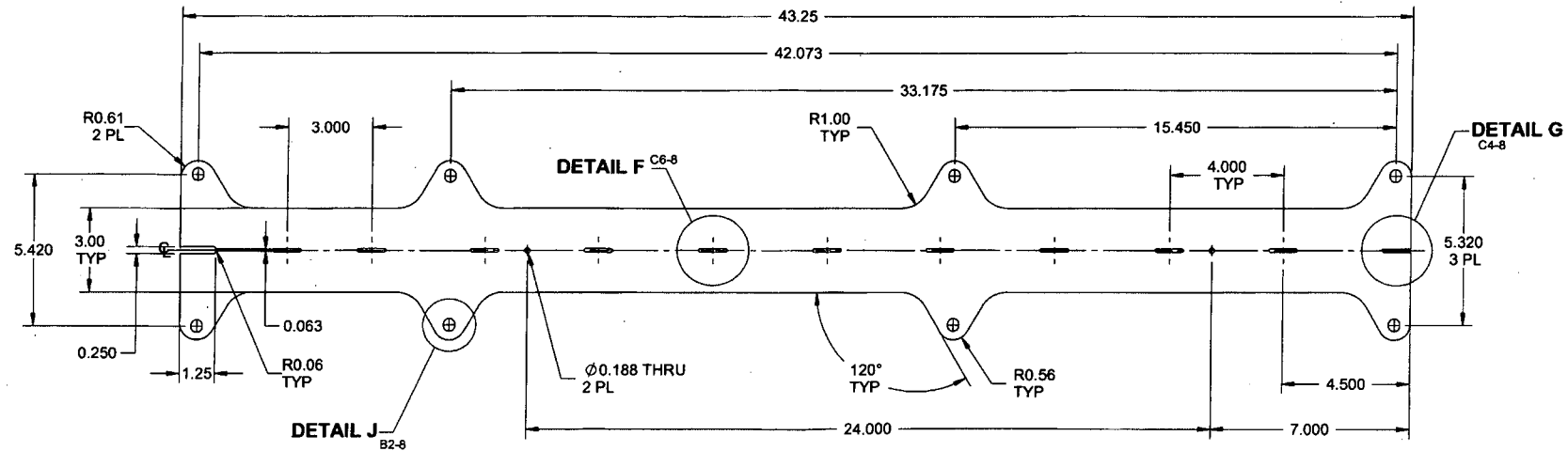
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AS	DRAWING NO. D3805	REV. C
MFG. APPR.	AS	SHEET 3 OF 8	
APPROVED	AS	TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.	AS	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.	
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8 7 6 5 4 3 2 1



D3805-1 PLATE
(MAKE FROM D3805-1F)



D3805-1F PLATE

RELEASED
2014-06-17
WM

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.11 lbs

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

8

7

6

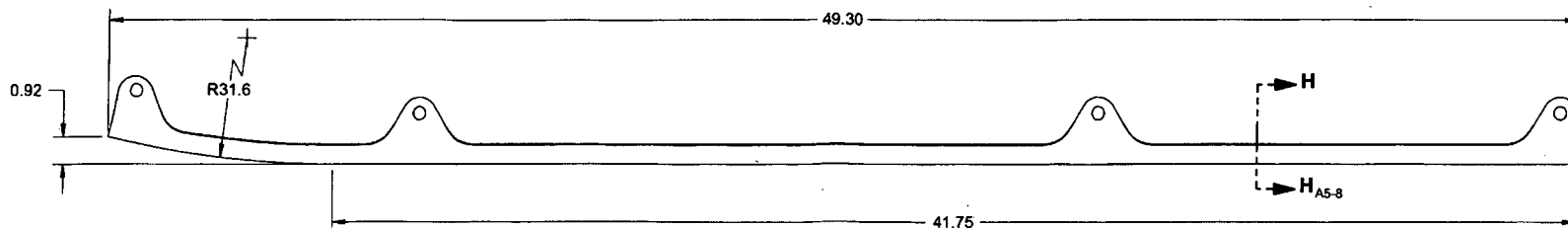
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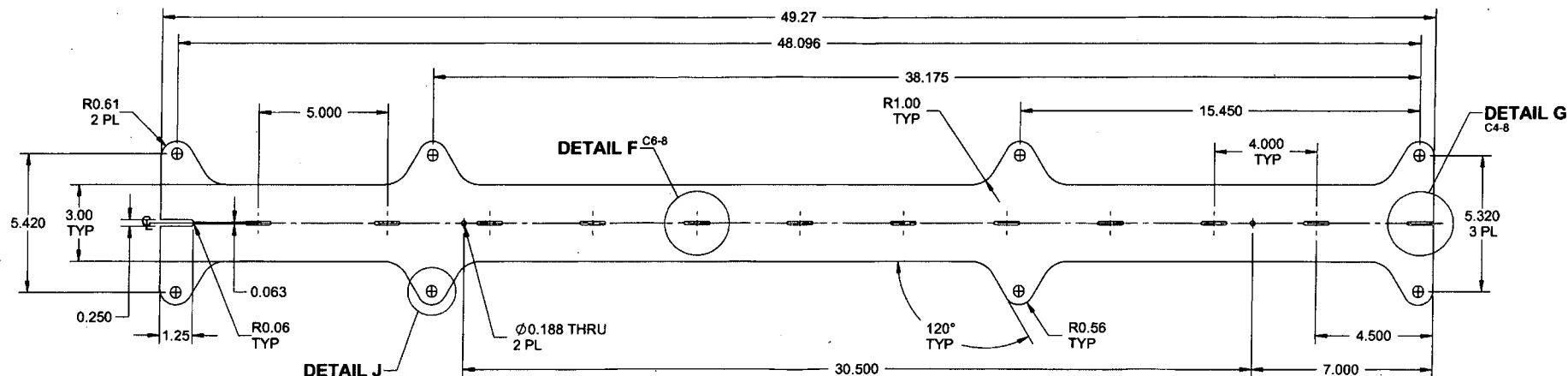
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2

1



D3805-3 PLATE
(MAKE FROM D3805-3F)



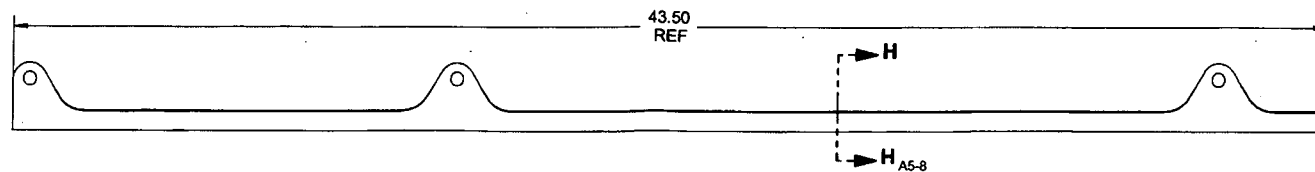
D3805-3F PLATE

RELEASED
2014-04-17

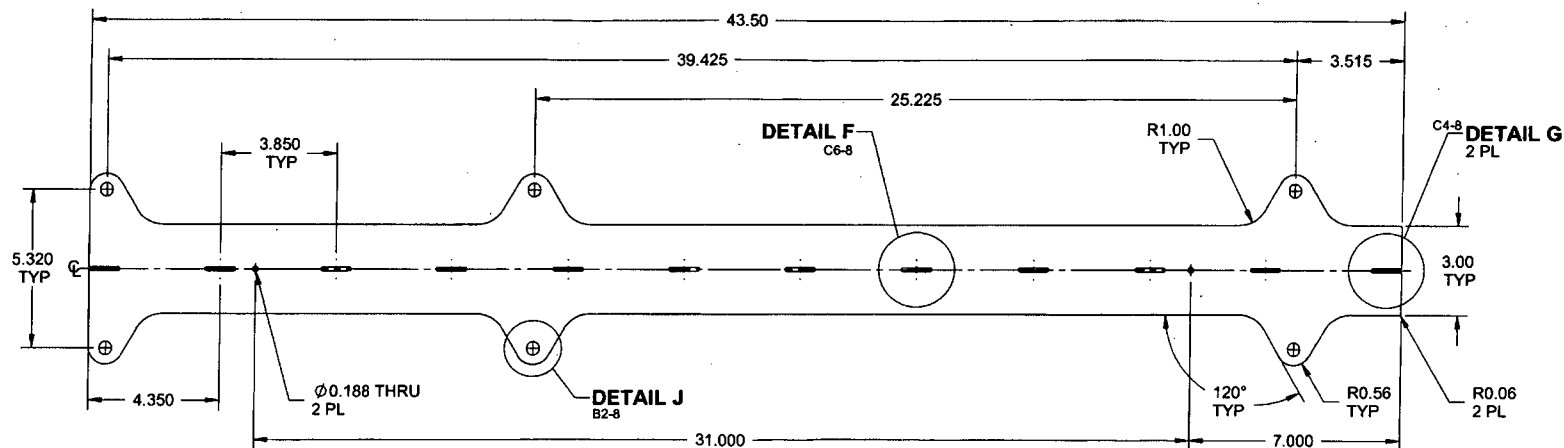
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.37 lbs

DESIGN	q	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3805	SHEET 5 OF 8
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	WEARPLATE ASSY	NTS
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D3805-5 PLATE
(MAKE FROM D3805-5F)



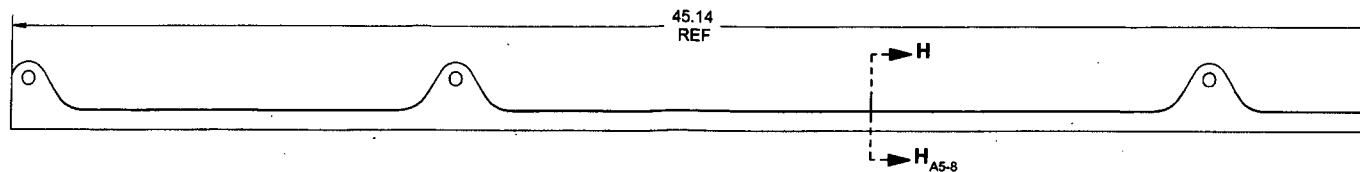
D3805-5F PLATE

RELEASED
2014-04-17
[Signature]

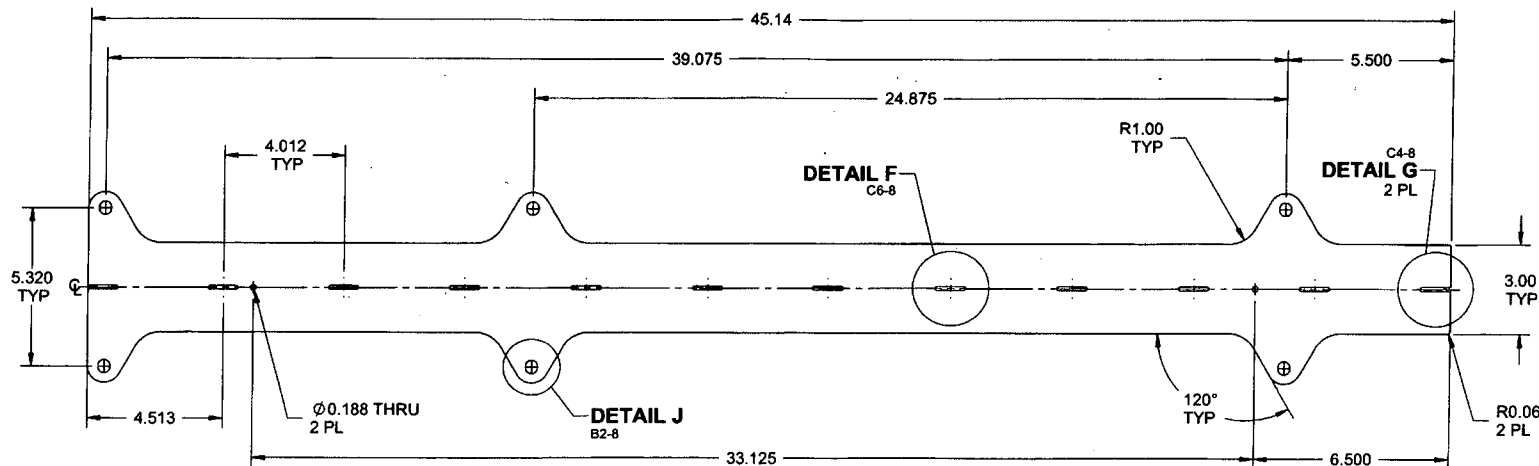
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

DESIGN	gp	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	ASS	D3805	SHEET 6 OF 8
APPROVED	ASS	TITLE	SCALE
DE APPR.	ASS	WEARPLATE ASSY	NTS
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D3805-7 PLATE
(MAKE FROM D3805-7F)



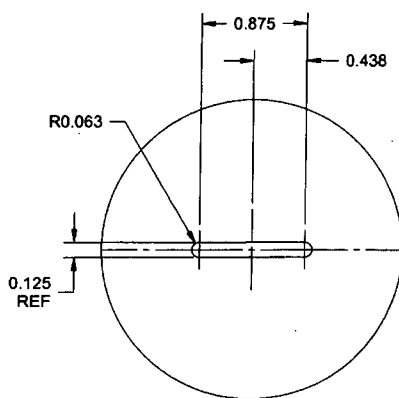
D3805-7F PLATE

RELEASED
2014-04-17

NOTES:

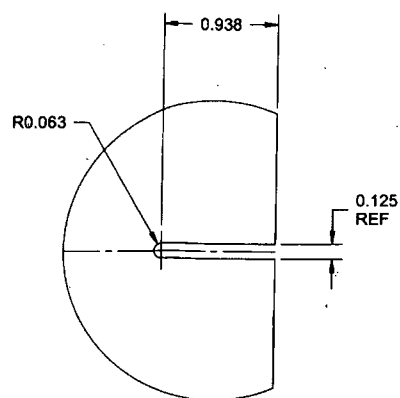
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3805	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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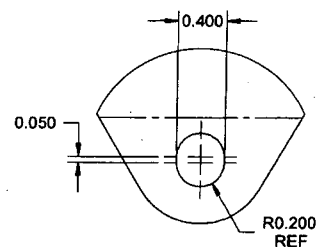
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



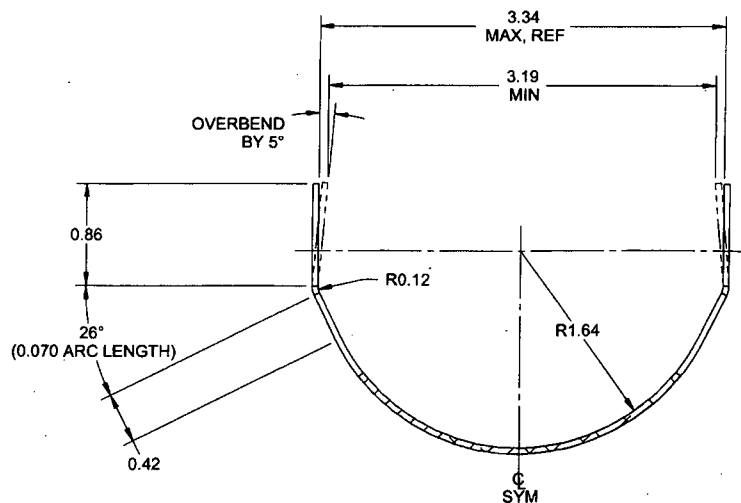
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

RELEASED
2014-04-17

DESIGN	9P	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	ASS	DRAWING NO. D3805	REV. C
MFG. APPR.			SHEET 8 OF 8
APPROVED		TITLE	SCALE
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